

# Work Order ID 71227

Friday, June 24, 2011 2:38:52 PM



*Moffitt*

Page 1

Item ID: D350-607-043A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D350-607-1

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-607-043A CHG001

*Subtotal*

*Order CL 11-6-27*

110

0.00



Pick Kit

Memo

0.00

Packaging

Packaging

*90 11/06/29*

120

0.00



Small Fab

Memo

0.00

Small Fab

Small Fab

Assemble as per Dwg D350-607  
Seal Support Gusset with Sikaflex -291  
Batch: *M116945*  
Exp Date: *12/01/15*

*11/07/05*

\_\_\_\_\_

Page 2

**Accept**

[illegible]**Setup Start**

**Stop**

**Cust Item ID:**

**Customer:**

**Reference:**

Run Start

### Tooling:

Date:

Date:

**SPC (Y/N):**

**Date:**

**Stop**

## Operation Description

## Set Up/ Run Hours

**Tool ID**

**Tool #**

## Plan Code

**Accept**  
**Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

QC5- Inspect part completeness to step on W/O

0.00



QC

## Memo

0.00

## Quality Control

## Pick Kit

0.00

\_\_\_\_\_

### Packaging

## Memo

0.00

## Packaging

QC4- 100% Inspect kits for completeness

0.00

**00000000000000000000**

QC

## Memo

0.00

**Work Order ID 71227**

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Item ID: D350-607-043A

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Packaging	0.00							
	Packaging								
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D350-607-043A								
	Location: _____								
170	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

6/25/11

11/7/11

MF 11-07-05

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Work Order ID: 71227

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)





Start Date: 6/24/2011

Required Date: 6/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevB: as per dwg revC DD 10.01.18 verified by:EC  
per ecn10-545 DD 10.04.19 verified by:EC  
IPP Rev:D 10.10.18 remove D350-607-143 and added individual parts of D350-607-143 in DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status															
AN310-4  NUT		Purchased	No			110	Each	120.0000	2	2	✓																	
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST324</td><td>120</td><td></td></tr><tr><td>117872</td><td>20</td><td>117872</td></tr><tr><td>118078</td><td>50</td><td></td></tr><tr><td>118112</td><td>50</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST324	120		117872	20	117872	118078	50		118112	50	
Location	Loc Qty	Loc Code																										
ST324	120																											
117872	20	117872																										
118078	50																											
118112	50																											
AN3C11A  BOLT		Purchased	No			110	Each	48.0000	2	2	✓																	
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST351</td><td>8</td><td></td></tr><tr><td>115590</td><td>8</td><td>116590</td></tr><tr><td>ST357</td><td>40</td><td></td></tr><tr><td>118116</td><td>40</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST351	8		115590	8	116590	ST357	40		118116	40	
Location	Loc Qty	Loc Code																										
ST351	8																											
115590	8	116590																										
ST357	40																											
118116	40																											
AN3C15A  Bolt		Purchased	No			110	Each	41.0000	2	2	✓																	
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST352</td><td>41</td><td></td></tr><tr><td>117792</td><td>41</td><td>117792</td></tr></table>														Location	Loc Qty	Loc Code	ST352	41		117792	41	117792						
Location	Loc Qty	Loc Code																										
ST352	41																											
117792	41	117792																										
D2728-3  Dart Logo label		Manufactured	No			110	Each	0.0000	2	2	✓																	

115050 JB

11/06/22

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Work Order ID: 71227

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/24/2011

Required Date: 6/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-11  
Gas Spring Spacer

Manufactured No

110 Each

3.0000

1

1

✓

Location

Loc Qty

Loc Code

ST096

3

68232

3

68232

D3953-15  
Gas Spring Bracket

Manufactured No

110 Each

7.0000

1

1

✓

Location

Loc Qty

Loc Code

ST101

7

68233

7

68233

D3953-17  
Gas Spring Spacer

Manufactured No

110 Each

20.0000

1

1

✓

Location

Loc Qty

Loc Code

ST096

20

69603

20

69603

D3953-3  
Gas Spring Stud, Lid

Manufactured No

110 Each

32.0000

1

1

✓

Location

Loc Qty

Loc Code

ST096

32

69611

4

69974

31

69974

D3953-5  
Gas Spring Stud, Base

Manufactured No

110 Each

9.0000

1

1

✓

Location

Loc Qty

Loc Code

ST096

9

69749

9

69749

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Page 2

D3953-7

1

B69975

ep.

ATG

69975

93

23

23

90

23

11/06/29

W/O: 71227		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/07/05	120	Add 1x D3953-7 to Bom per attached Perman. chg. B# 69975	ep	11/07/05	1	U 11/07/05	S 11/07/05

Part No: D350-607-043A PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## 6.3 D350-607-141/-143/-145 AUTOMATIC LID OPENER INSTL

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-607-141	AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET)
	X		D350-607-143	AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET)
		X	D350-607-145	AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET)
2		1	D3953-1	GAS SPRING BRACKET
2	1	1	D3953-3	GAS SPRING STUD (LID)
2	1	1	D3953-5	GAS SPRING STUD (BASE)
2	1	1	D3953-7	GAS SPRING SPACER
4	2	2	D3953-9	GAS SPRING WASHER
2	1	1	D3953-11	GAS SPRING SPACER
2		1	D3953-13	GAS SPRING SPACER
	1		D3953-15	GAS SPRING BRACKET
	1		D3953-17	GAS SPRING SPACER
2	1	1	D3969-1	GAS SPRING
4	2	2	AN3C11A	BOLT
	2		AN3C15A	BOLT
4		2	AN3C16A	BOLT
4	2	2	AN310-4	CASTELLATED NUT
8	4	4	MS21043-3	NUT
4	2	2	MS24665-212	COTTER PIN
8	4	4	NAS1149C0332R	WASHER (OR AN960C10L)
4	2	2	NAS1149C0432R	WASHER (OR AN960C416L)

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Work Order ID: 71227

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/24/2011

Required Date: 6/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-9  
Gas Spring Washer

Manufactured No

110 Each

45.0000

2

2

✓



JB

Location

Loc Qty

Loc Code

ST096

45

69025

5

69973

40

69973

D3969-1  
Spring (Basket Lid)

Manufactured No

110 Each

1.0000

1

1

✓



JB

Location

Loc Qty

Loc Code

ST272

1

52889

1

52889

MS21043-3  
Nut

Purchased No

110 Each

1,169.000

4

4

✓



JB

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1097

112314

97

118077

1000

112314

MS24665-2-12  
COTTER PIN

Purchased No

110 Each

214.0000

2

2

✓



JB

Location

Loc Qty

Loc Code

ST308

200

118078

200

ST309

14

111499

14

111499

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11/06/29



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Work Order ID: 71227

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/24/2011

Required Date: 6/28/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

110

Each

1,133.000

4

4

✓



Washer

## Location

## Loc Qty

## Loc Code

FP-B

15

117291

15

ST297

1118

116304

55

117460

260

117887

557

118078

246

117460

NAS1149C0432R

Purchased

No

110

Each

5,348.000

2

2

✓



Washer

## Location

## Loc Qty

## Loc Code

ST297

5348

116900

422

117291

4926

140

Each

2.0000

1

1

D350-607-241

Manufactured

No



Basket Clamp Assembly

## Location

## Loc Qty

## Loc Code

FG022

2

69946

1

70783

1

117291

369946

1

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Work Order ID: 71227

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/24/2011

Required Date: 6/28/2011

Start Qty: 1.00

Required Qty: 1.00

D2022-101  
Spacer

Manufactured No

110 Each

86.0000

5

5

✓

Location

Loc Qty

Loc Code

ST504

86

69532

26

69824

60

69532

D2221  
350 Basket Base

Manufactured No

110 Each

0.0000

1

1

D2258-200

Manufactured No

110 Each

7.0000

1

1

Placard 200lb

Location

Loc Qty

Loc Code

ST505

7

64284

1

68928

6

68928

D2530

Manufactured No

110 Each

11.0000

1

1

Handle Weldment

Location

Loc Qty

Loc Code

ST506

1

68363

1

ST508

10

69318

10

69318

B70566

(R)

6/24/07/05

JB

JB

11/06/29

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# Picklist Print

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Work Order ID: 71227

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/24/2011

Required Date: 6/28/2011

Start Qty: 1.00

Required Qty: 1.00

D2535  
Spring  
Manufactured No

110 Each 37.0000 2 2 ✓



JB

Location	Loc Qty	Loc Code
ST504	37	
66764	9	
69495	28	

66764

D2537  
Bushing  
Manufactured No

110 Each 32.0000 2 2 ✓



JB

Location	Loc Qty	Loc Code
ST504	32	
66972	2	
69894	30	

66972

D2931  
Bumper  
Manufactured No

110 Each 638.0000 2 2 ✓



JB

Location	Loc Qty	Loc Code
ST504	638	
46064	638	

46064

11/06/29

D2989-041  
Basket Lid Assembly  
Manufactured No

110 Each 0.0000 1 1



B70564

6/24/07/05

D2989-043  
Basket Lid Assembly  
Manufactured No

110 Each 0.0000 1 1



B70565

6/24/07/05

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Work Order ID: 71227

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/24/2011

Required Date: 6/28/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-16A  
Bolt

Purchased No

110 Each

121.0000 2

2

✓



23

Location

Loc Qty

Loc Code

ST352

121

116419

21

117441

100

AN4-13A

Purchased No

110 Each

886.0000 2

2

✓



23

Location

Loc Qty

Loc Code

ST357

886

117962

286

118078

600

117962

AN4-22A

Purchased No

110 Each

183.0000 5

5

✓



23

Location

Loc Qty

Loc Code

ST359

183

114784

35

116419

49

117313

99

114784

AN5-17A

Purchased No

110 Each

100.0000 4

4

✓



23

11/06/29

Location

Loc Qty

Loc Code

ST339

100

117619

50

117872

50

117619

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Work Order ID: 71227

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/24/2011

Required Date: 6/28/2011

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

110

Each

933.0000

2

2

✓



Cherry Rivets



JB

## Location

## Loc Qty

## Loc Code

ST321

800

111636

114

117505

500

117601

186

WA018

133

107939

133

117601

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

0.0000

14

14

✓



Washer



117460

JB

AN960JD516

NAS1149D0563J

Purchased

No

110

Each

0.0000

4

4

✓



Washer



117591

JB

AN960JD8

NAS1149DN832J

Purchased

No

110

Each

0.0000

2

2

✓



Washer



117316

JB

NAS1515H4

Purchased

No

110

Each

182.0000

2

2

✓



Washer



JB

11/06/29

## Location

## Loc Qty

## Loc Code

ST277

182

111525

2

116169

3

117460

50

117735

77

118078

50

117735

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Work Order ID: 71227

Parent Item: D350-607-043A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 6/24/2011

Required Date: 6/28/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

1,959.000

2

2

✓



Nut



JB

Location

Loc Qty

Loc Code

ST300

1959

116549

259

117441

800

117601

400

117885

500

116549

MS21042L4

Purchased

No

110

Each

4,734.000

7

7

✓



Nut



JB

Location

Loc Qty

Loc Code

ST300

4734

117441

2445

117601

789

117885

1500

117441

MS21042L5

Purchased

No

110

Each

986.0000

4

4

✓



Nut



JB 11/06/29

Location

Loc Qty

Loc Code

ST300

986

116105

28

116548

260

117441

498

117591

100

117611

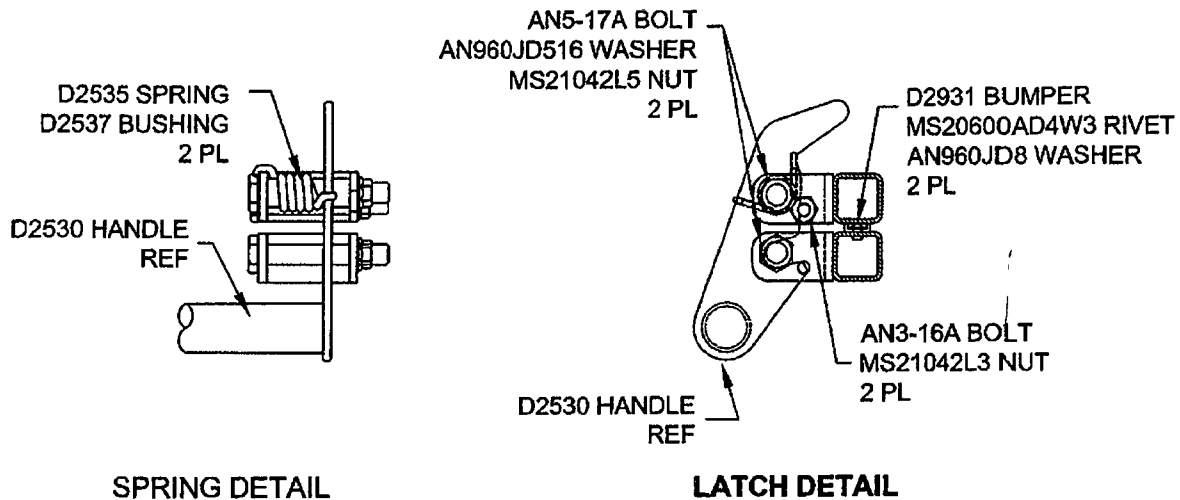
100

116548

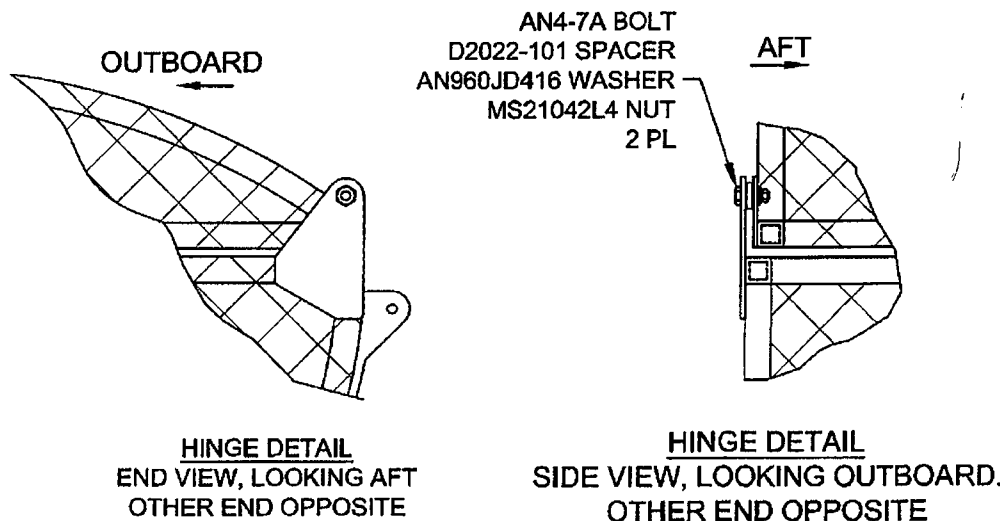
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**DETAIL J:**  
**HANDLE WELDMENT**



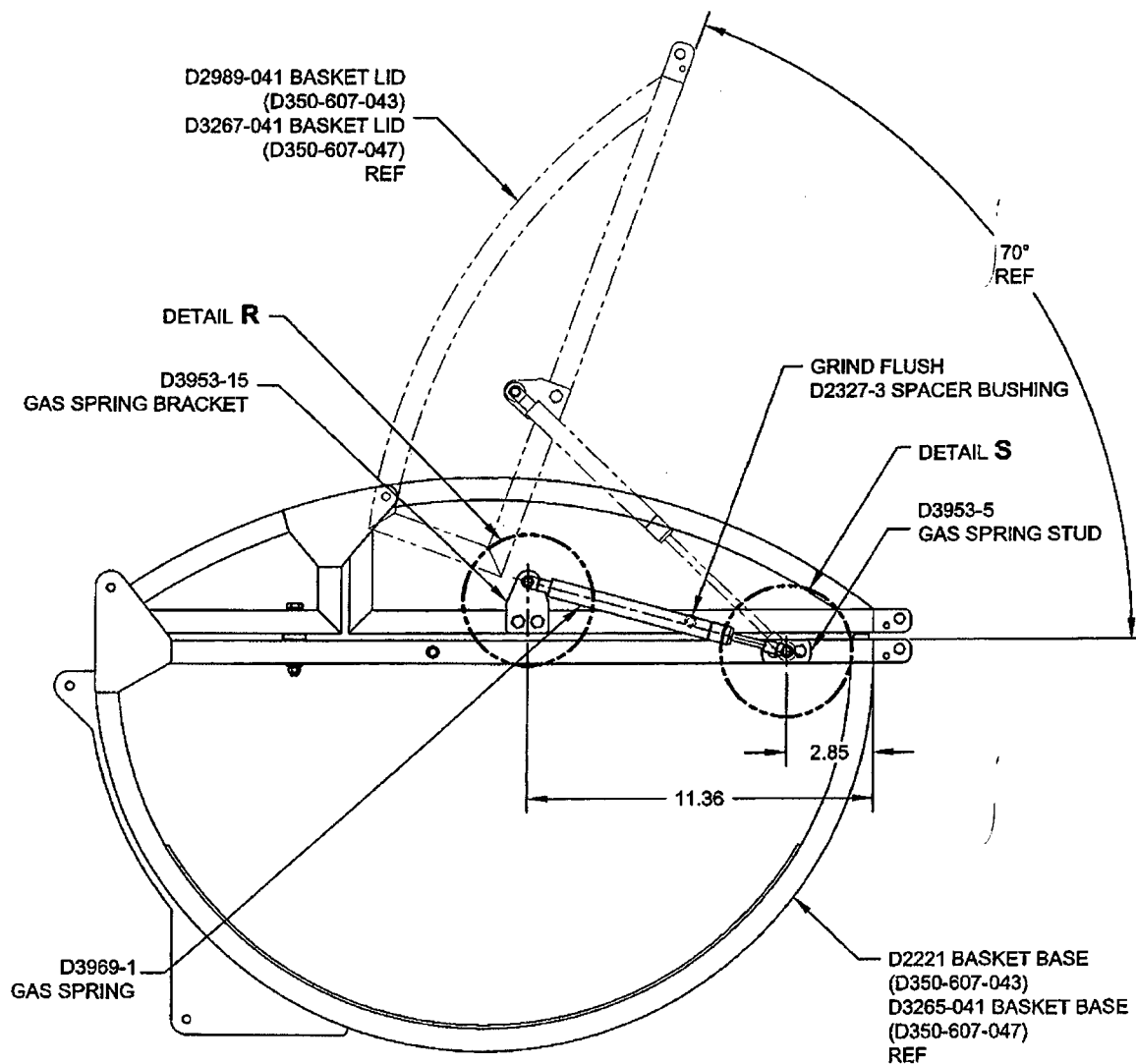
**DETAIL H:**  
**HINGE**

*Wb 71227*

**Figure 7 – Basket Replacement Parts**

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Revision: **A**  
Date: 10.03.10



**D350-607-143 AUTOMATIC LID OPENER INSTALLATION**  
(1 END ONLY)

71227

**Figure 9a – Automatic Lid Opener Installation**

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